

Date: Wednesday, 9/12/2007 12:14:19 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE	
Job Number	: 34624		Part Number	: D353515	
Estimate Number	: 12736		Drawing Number	: D3535 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 9/12/2007	S.O. No. : N/A	Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 9/30/2007	
Previous Run	: 32737		Qty:	30	
Written By	: <u>SD</u>		Um:	Each	
Checked & Approved By	: <u>SD 07.09.12</u>				
Comment	: Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet 
Comment: Qty.: 1.0715 sf(s)/Unit Total : 21.4305 sf(s) 304/316 .040 Sheet (M304S20GA) Batch: <u>m165824</u> <u>IB 07-10-2</u>		
2.0	WATER JET	FLOW WATER JET 
Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: <u>B</u> <u>IB 07-10-2</u> Prog Rev: <u>B</u>		
2-Deburr if necessary <u>IB 07-10-2</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>IB 07-10-2</u>		
4.0	QC8	SECOND CHECK 
Comment: SECOND CHECK <u>IB 07-10-03</u> <u>counts</u>		
5.0	BRAKE NC	NC BRAKE 
Comment: NC BRAKE 1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-15 <u>IB 07/10/03</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/10/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARSHOE
Job Number: 34624		Part Number: D353515
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP  <span style="float: right;">counts en 07/10/03 x28</span>
7.0	POWDER COATING	POWDER COATING  <span style="float: right;">M104846</span>
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  <span style="float: right;">29IX</span>
9.0	PACKAGING 1	PACKAGING RESOURCE #1  <span style="float: right;">29IX</span>
10.0	QC21	FINAL INSPECTION/W/O RELEASE  <span style="float: right;">29IX m/f 07/10/04</span>
Comment: FINAL INSPECTION/W/O RELEASE		<span style="float: right;">m/f 07/10/04</span>
Job Completion 		<span style="float: right;">m/f 07/10/04</span>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34624
Description: Wearshoe	Part Number:	D3535-15
Inspection Dwg: D3535	Rev: B	Page 1 of 1

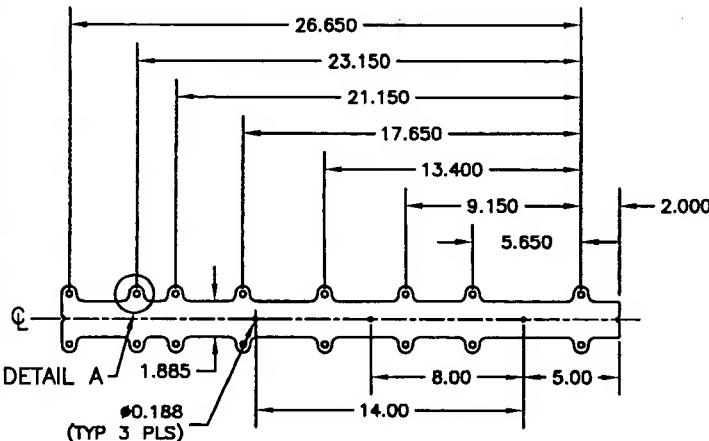
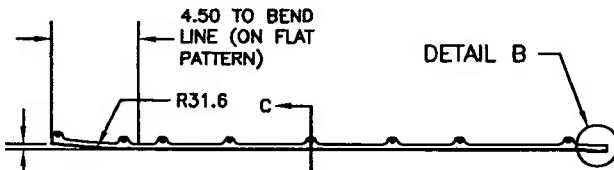
### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.885	X			
2.000	+/-0.010	2.000	X			
5.650	+/-0.010	5.650	X			
9.150	+/-0.010	9.150	X			
14.400	+/-0.010	14.400	X			
19.650	+/-0.010	19.650	X			
24.900	+/-0.010	24.900	X			
30.150	+/-0.010	30.150	X			
33.650	+/-0.010	33.650	X			
35.650	+/-0.010	35.650	X			
39.150	+/-0.010	39.150	X			
Ø0.188	+0.005/-0.001	.191	X			
24.00	+/-0.030	24.00	X			
16.00	+/-0.030	16.00	X			
8.00	+/-0.030	8.00	X			
5.00	+/-0.030	5.00	X			
0.300	+/-0.010	.302	X			
0.300	+/-0.010	.303	X			
0.038	+/-0.010	.036	X			

Measured by:	<i>BR</i>	Audited by:	<i>CM</i>	Prototype Approval:	N/A
Date:	07-10-2	Date:	<i>07-10-03</i>	Date:	N/A

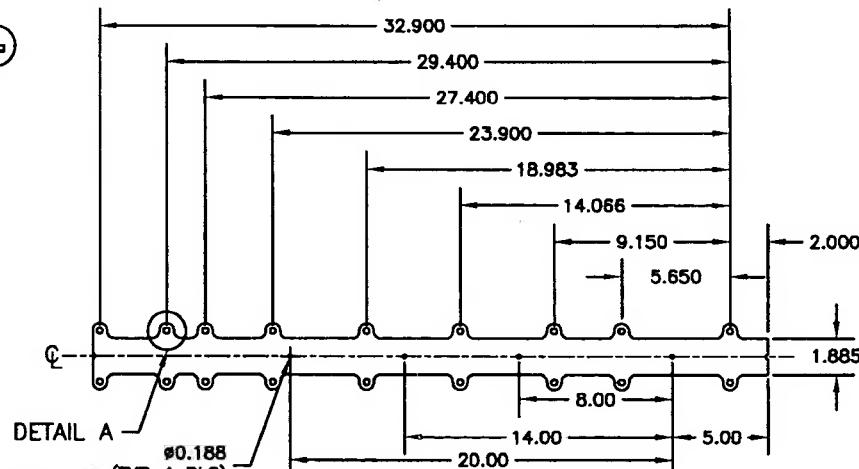
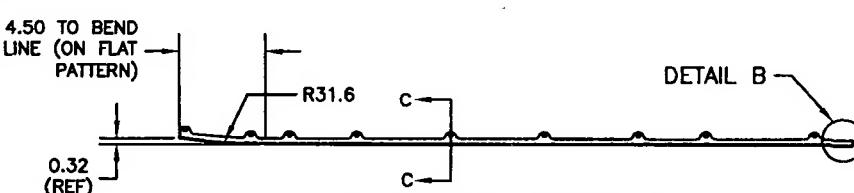
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM <i>✓</i>	<i>BR</i>

**DART****D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL**

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34624

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
<b>C8</b>	<b>PH</b>	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>PH</i>	<i>PH</i>	D3535
07.04.17	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

REV. B  
SHEET 1 OF 7  
SCALE 1:10

NO. 34624

4.50 TO BEND  
LINE (ON FLAT  
PATTERN)

0.32  
(REF)

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WITHOUT NOTICE  
WORK ORDER

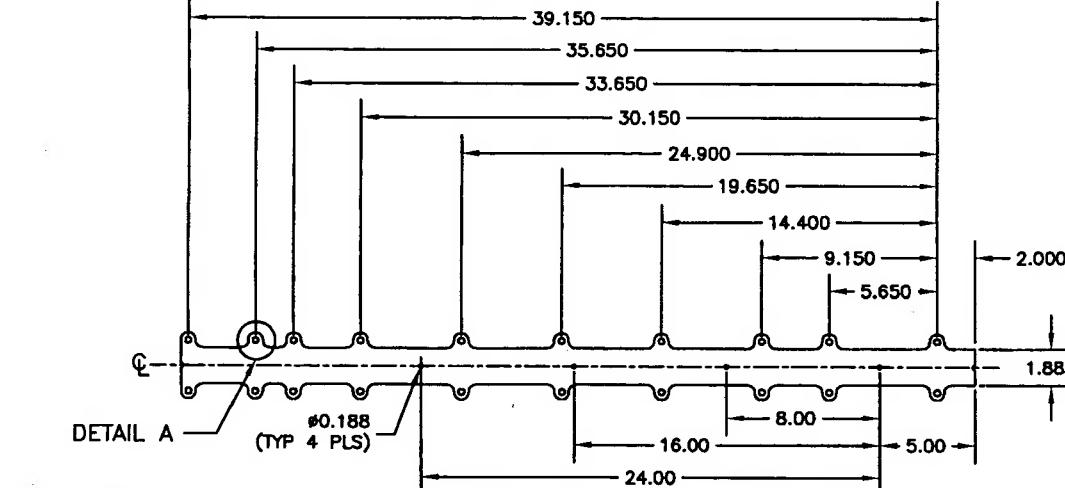
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**D3535-15 BEND DETAIL**

DETAIL A

0.188  
(TYP 4 PLS)

DETAIL B



**D3535-15F FLAT PATTERN**

**NOTES**

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QSI 005 4.3
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PAINT MARKER
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DETAIL A

2.000

5.450

10.900

16.350

21.800

27.250

32.700

2.000

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24.00

27.250

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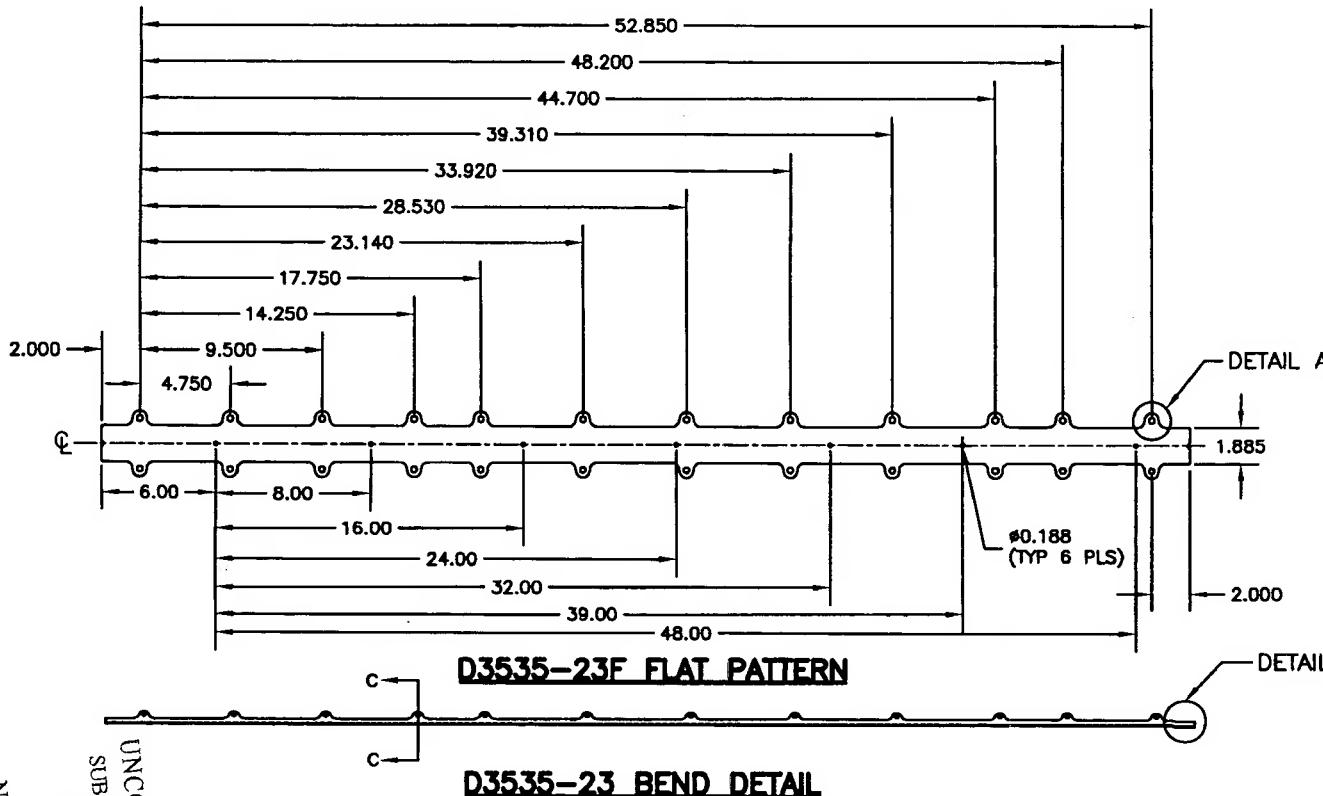
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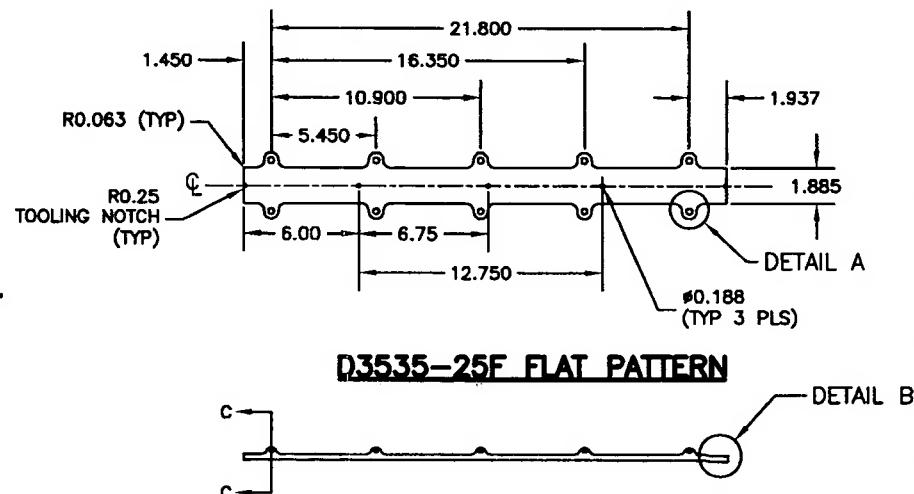
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C.B	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
	PH	D.3535
DATE		TITLE
07.04.17		WEARSHOE
REV. B		SHEET 3 OF 7
		SCALE
		1:10

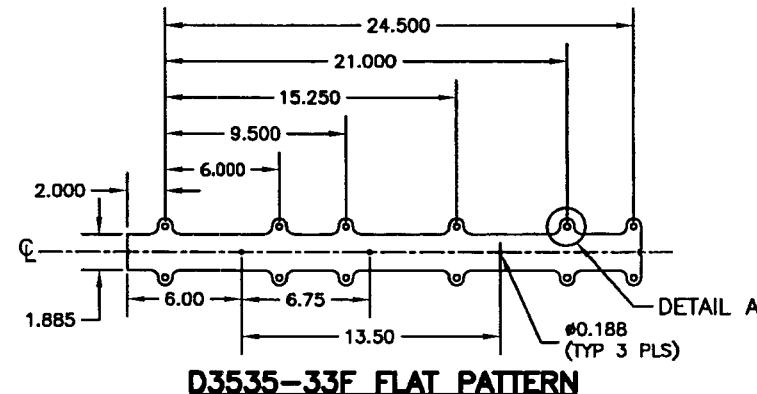
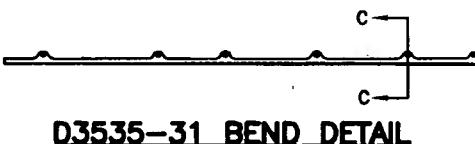
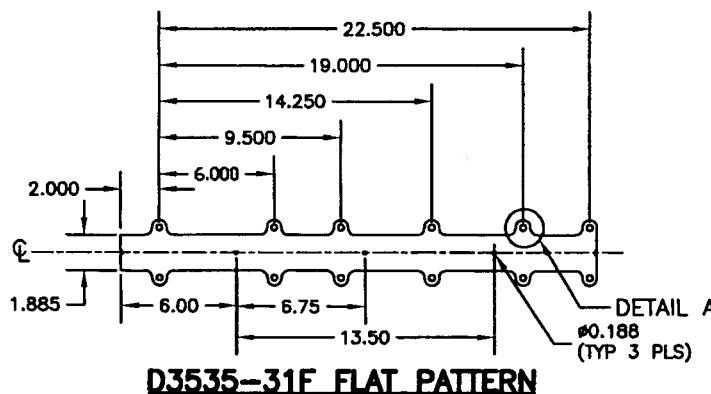
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WORK ORDER  
NO 34624

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

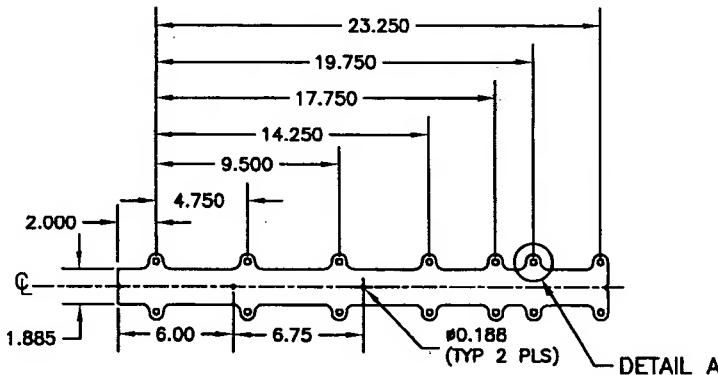
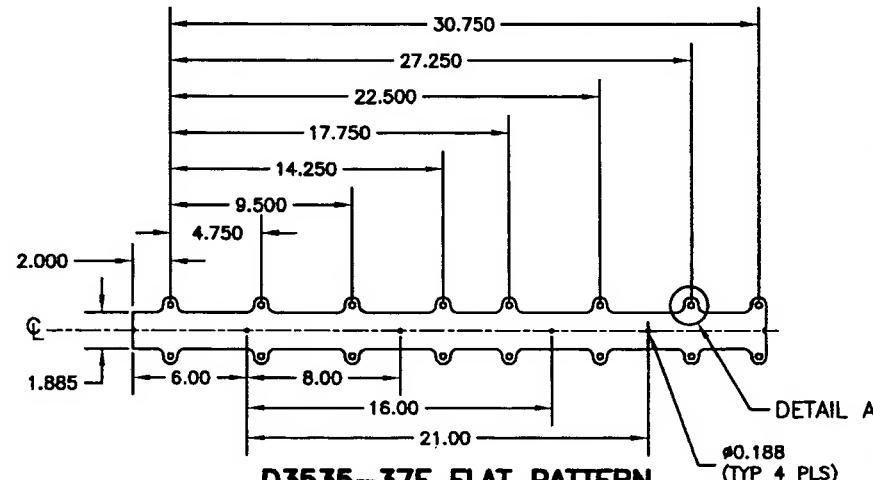


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		D3535
DATE		SCALE
07.04.17		1:10

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07.04.17**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

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NO 24624

**NOTES**

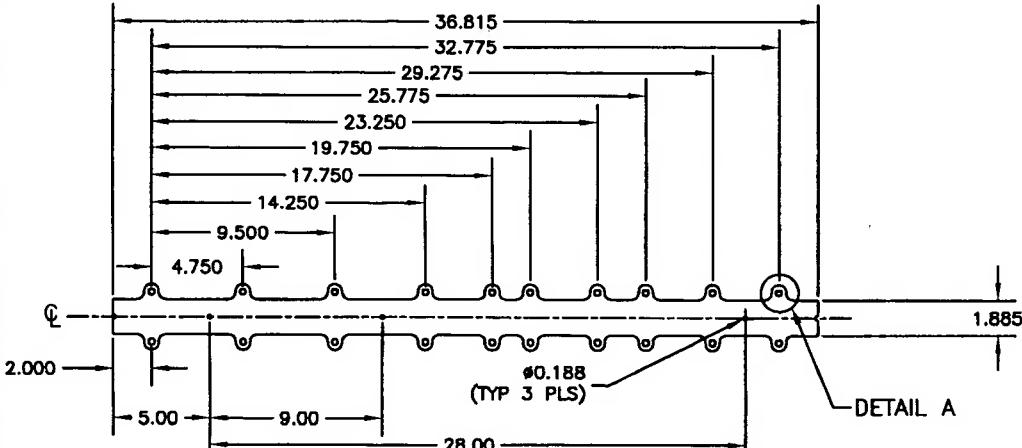
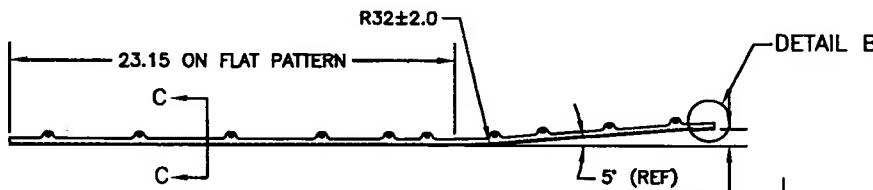
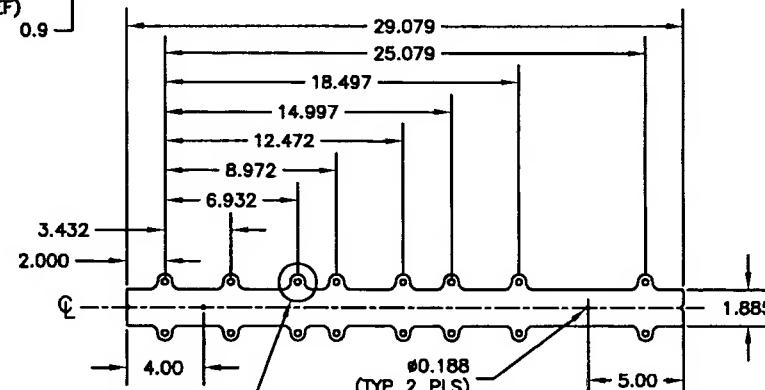
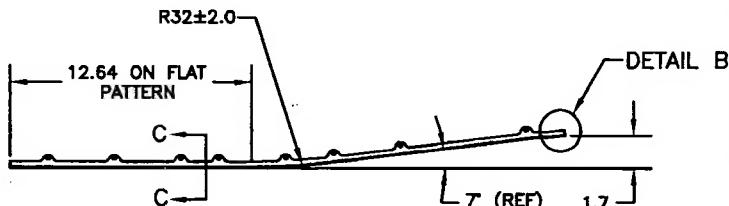
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DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. B
CB	PH	DRAWING NO. D3535	SHEET 5 OF 7
CHECKED	PH	DATE 07.04.17	SCALE 1:10

**DART**

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<b>C.B</b>	<b>PH</b>	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
07.04.17		D3535
		WEARSHOE
		SHEET 6 OF 7
		REV. B
		1:10

RELEASED  
07.04.24

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

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WORK ORDER  
NO. 34624

**NOTES**

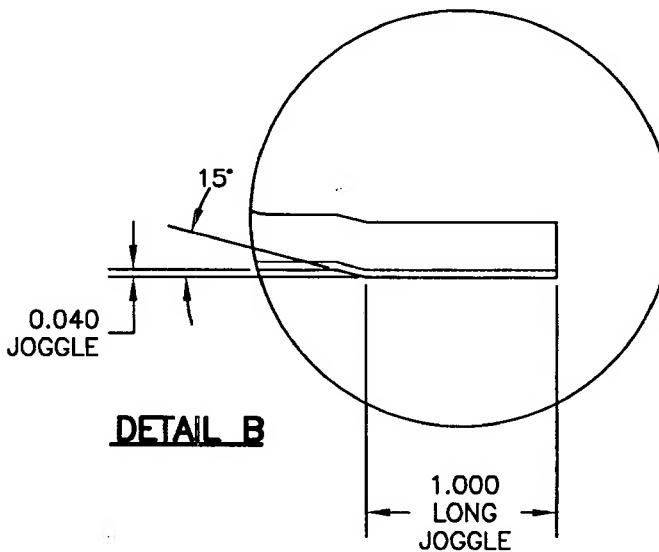
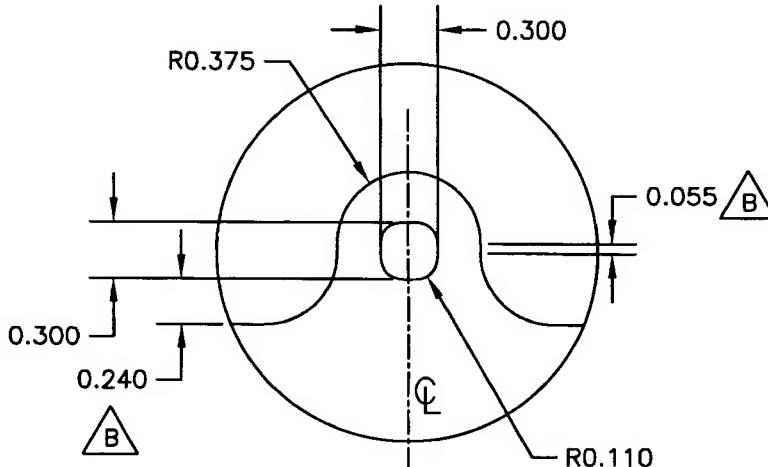
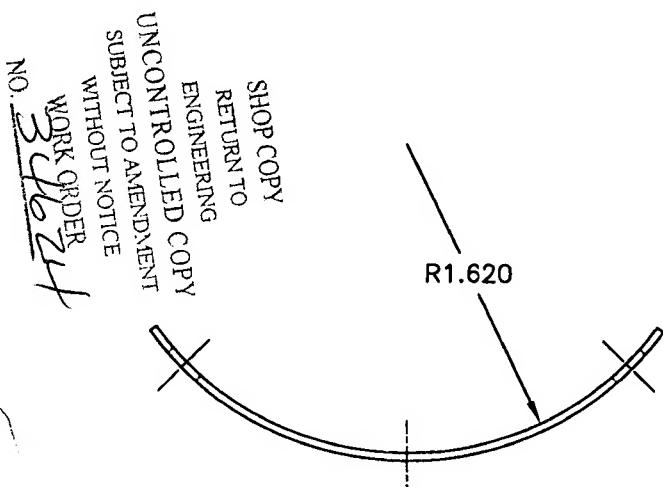
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**DART**

DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 7 OF 7 SCALE 1:1

**RELEASED**  
*[Signature]*

07.04.24

**DETAIL B****DETAIL A****SECTION C-C**

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